

Date: Wednesday, 11/03/2009 12:59:02 PM  
 User: Julie Dawson

## Process Sheet

|                                  |  |                         |              |
|----------------------------------|--|-------------------------|--------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b>     | : WEARSHOE   |
| <b>Job Number</b>                | : 46442  |                         |              |
| <b>Estimate Number</b>           | : 12788  |                         |              |
| <b>P.O. Number</b>               | :  | <b>Part Number</b>      | : D356413    |
| <b>This Issue</b>                | : 11/03/2009   | <b>S.O. No.</b>         | :            |
| <b>Prsht Rev.</b>                | : NC   | <b>Drawing Number</b>   | : D3564 REVD |
| <b>First Issue</b>               | : / /  | <b>Project Number</b>   | : N/A        |
| <b>Previous Run</b>              | : 46183  | <b>Drawing Revision</b> | : D          |
|                                  | <b>Type</b>  | <b>Material</b>         | :            |
|                                  | : SMALL /MED FAB   | <b>Due Date</b>         | : 23/03/2009 |
| <b>Written By</b>                | :  | <b>Qty:</b>             | 12           |
| <b>Checked &amp; Approved By</b> | : <u>JUL 09.03.11</u>  | <b>Um:</b>              | Each         |
| <b>Comment</b>                   | : Est Rev:A New Issue 07-03-08 ec<br>Est Rev:B As per Rev C 07-07-09 JLM<br>Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC<br>Est Rev:D Comments revised on Step 5, 6 per B44657<br>09-02-04 KJ Verified By:EC |                         |              |

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 Sheet .063



**Comment:** Qty.: 0.2331 sf(s)/Unit Total : 2.7972 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: 111323 LB 9-4-5

2.0

WATER JET

FLOW WATER JET

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: DProg Rev: DLB 9-4-5

(12)

2-Deburr if necessary

LB 9-4-5

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

LB 9-4-5**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK
502/04/06 (12)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 11/03/2009 12:59:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 46442

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 8179

09/04/09 (12)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/08 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(12)

START TIME:

12:15

OVEN TEMPERATURE:

328°

FINISH TIME:

12:45

FL 09/04/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-9

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-17

BR 09-04-9 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



MF 09-04-14

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

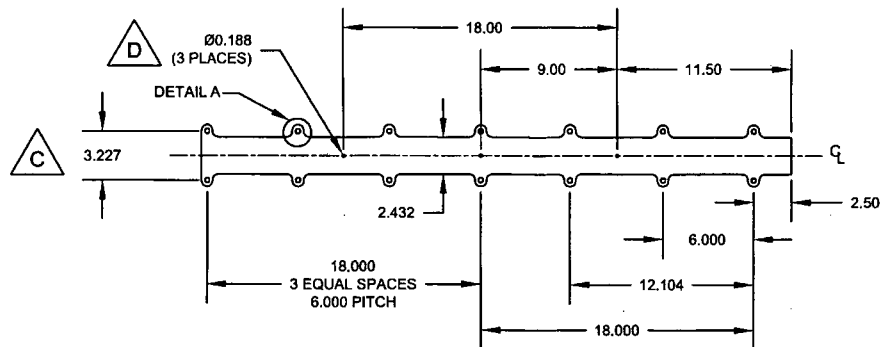
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

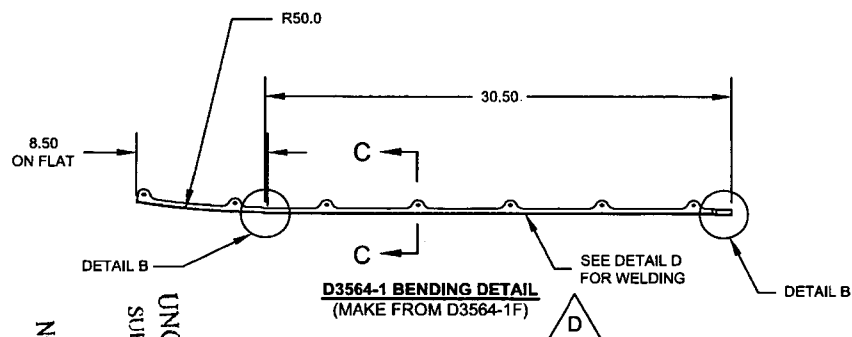




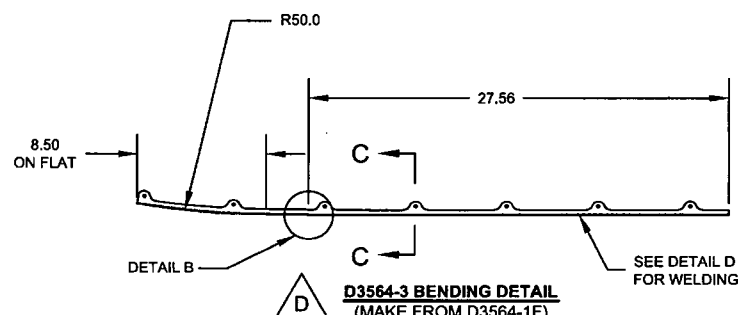
**D3564-1F FLAT PATTERN**

**RELEASED**

07.09.04



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

NO  
WORK  
ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

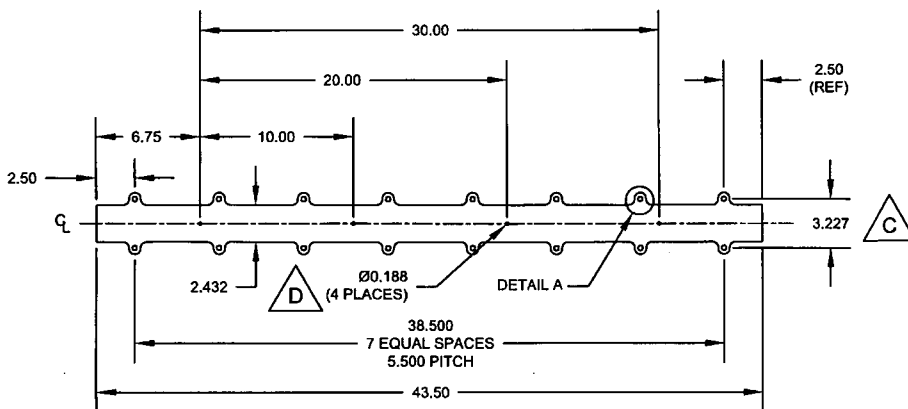
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT Q

| WEIGHTS: |          |
|----------|----------|
| D3564-1  | 1.85 lbs |
| D3564-3  | 1.85 lbs |
| D3564-5  | 1.93 lbs |
| D3564-7  | 1.26 lbs |
| D3564-9  | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

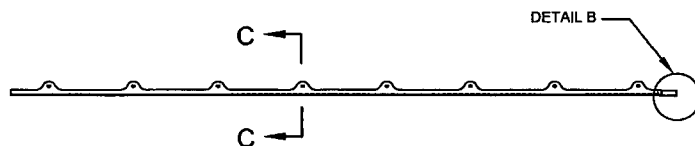
|            |   |  |          |
|------------|---|--|----------|
| D          | UPDATE DRAWING TEMPLATE;<br>CHANGE ALL (TYP X PLS) TO (X PLACES);<br>PG1 A8, PG3 B5,C5: ADD D3564-15;<br>PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE;<br>PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE;<br>PG2 A7,A3: D3564-9/-11 WAS ON PG1;<br>PG3 B6,C8: D3564-13 WAS ON PG2;<br>PG3 D2: WELDING DETAIL WAS ON PG1<br>PG3 A5,7,B2: RELOCATE DETAILS AND SECTION;<br>PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB   | 07.08.21 |
| C          | MOVE TAB OUTBOARD, DETAIL A   | PH   | 07.04.17 |
| B          | ADD AMS 5513 AND AMS 5524   | PH   | 07.03.20 |
| A          | NEW ISSUE   | PH   | 06.12.18 |
| REV.       | DESCRIPTION   | BY   | DATE     |
| DESIGN     | PH  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |          |
| DRAWN      | CB  |  |          |
| CHECKED    | PH  |  |          |
| MFG. APPR. | PH  |  |          |
| APPROVED   | PH  |  |          |
| DE APPR.   | PH  | WEARSHOE   |          |
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8 7 6 5 4 3 2 1

D

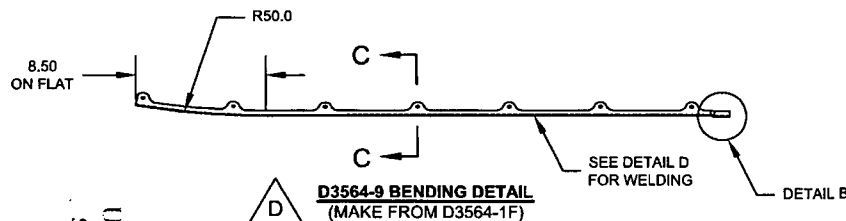


**D3564-5F FLAT PATTERN**



**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)

B



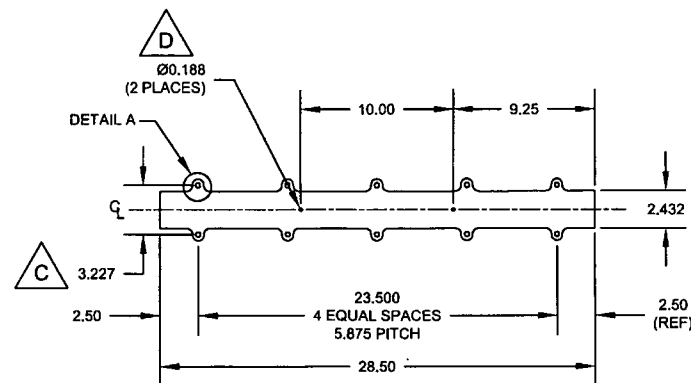
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)

A

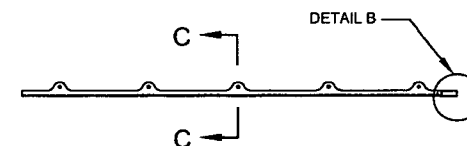
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WORK ORDER NO. 4644

8 7 6 5 4 3 2 1

D



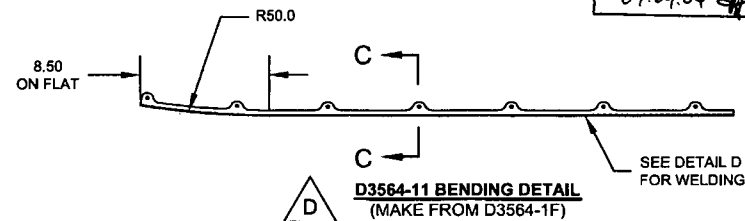
**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)

C

B



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

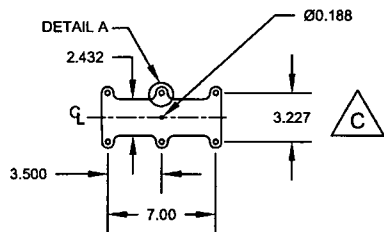
RELEASED  
07.09.04

A

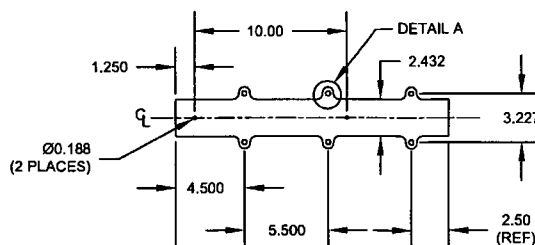
|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | CB       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | PH       | DRAWING NO. D3564  | REV. D       |
| MFG. APPR. | PH       |  | SHEET 2 OF 3 |
| APPROVED   | PH       | TITLE WEARSHOE   | SCALE        |
| DE APPR.   | PH       |  | 1:8          |
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1

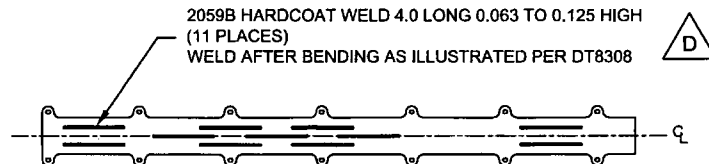
8 7 6 5 4 3 2 1



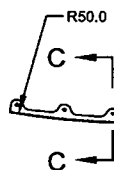
**D3564-13F FLAT PATTERN**



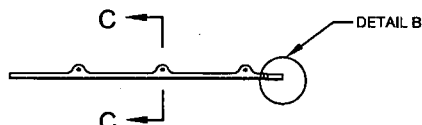
**D3564-15F FLAT PATTERN**



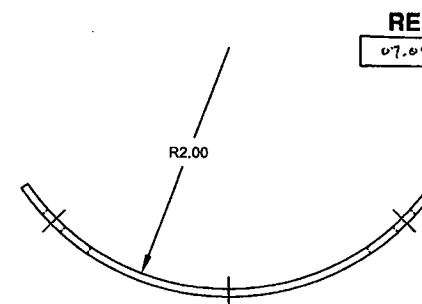
**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



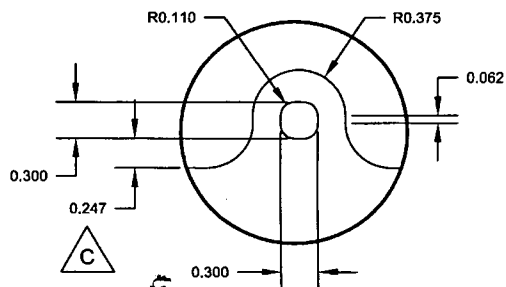
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



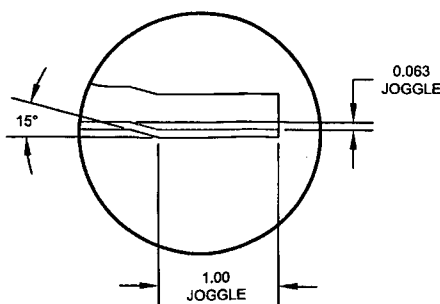
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

RELEASED

07.09.04

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | CB       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | PH       | DRAWING NO.  | REV. D       |
| MFG. APPR. | PH       | D3564  | SHEET 3 OF 3 |
| APPROVED   | PH       | TITLE  | SCALE        |
| DE APPR.   | PH       | WEARSHOE   | 1:8          |
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